

Date: Friday, 07/12/2007 7:42:47 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 36171	
Estimate Number : 10747	
P.O. Number :	Part Number : D33153
This Issue : 07/12/2007 S.O. No. :	Drawing Number : D3315 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 25726	Material :
Written By :	Due Date : 24/12/2007 Qty: 6 Um: Each
Checked & Approved By :	
Comment : Est: A 05.05.12 New issue KJ/JLM Est Rev:B As per Rev B 06-03-24 JLM Est Rev:C Now on Waterjet 07-07-11 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S16GA	1010/1025/A21/6aA SHEET
-----	------------	-------------------------



Comment: Qty.: 2.4108 sf(s)/Unit Total : 14.4648 sf(s)

1010/1025/A21/6aA SHEET .060" THK

BATCH: 105706 IB 07-12-10

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3315

Dwg Rev: B

Prog Rev: B

IB 07-12-10

2-Deburr if necessary

IB 07-12-10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

IB 07/12/10 (48)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------

**Comment:** NC BRAKE

1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: B

SB 07/12/10 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 07/12/2007 7:42:47 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 36171

Part Number: D33153

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Handwritten: 7/12/11 (x8)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3315-3T3 as per QSI 004 and Dwg D3315 Rev: 12

Qty Part Number Description

Batch

A/R N/A

7560 Hardcoat Rod

m106390

Handwritten: FC 08/01/16 (8)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 08/01/17 (8)

Handwritten: 10 08/01/17 (3)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Handwritten: M 106442

Handwritten: m-1 08/01/18

Handwritten: (8X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Handwritten: BK 08-01-18 (8)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-3, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location:

Handwritten: ST497

Handwritten: AS 08/01/18 (x8)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 10 08.01.21

Job Completion



Handwritten: L 08/01/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

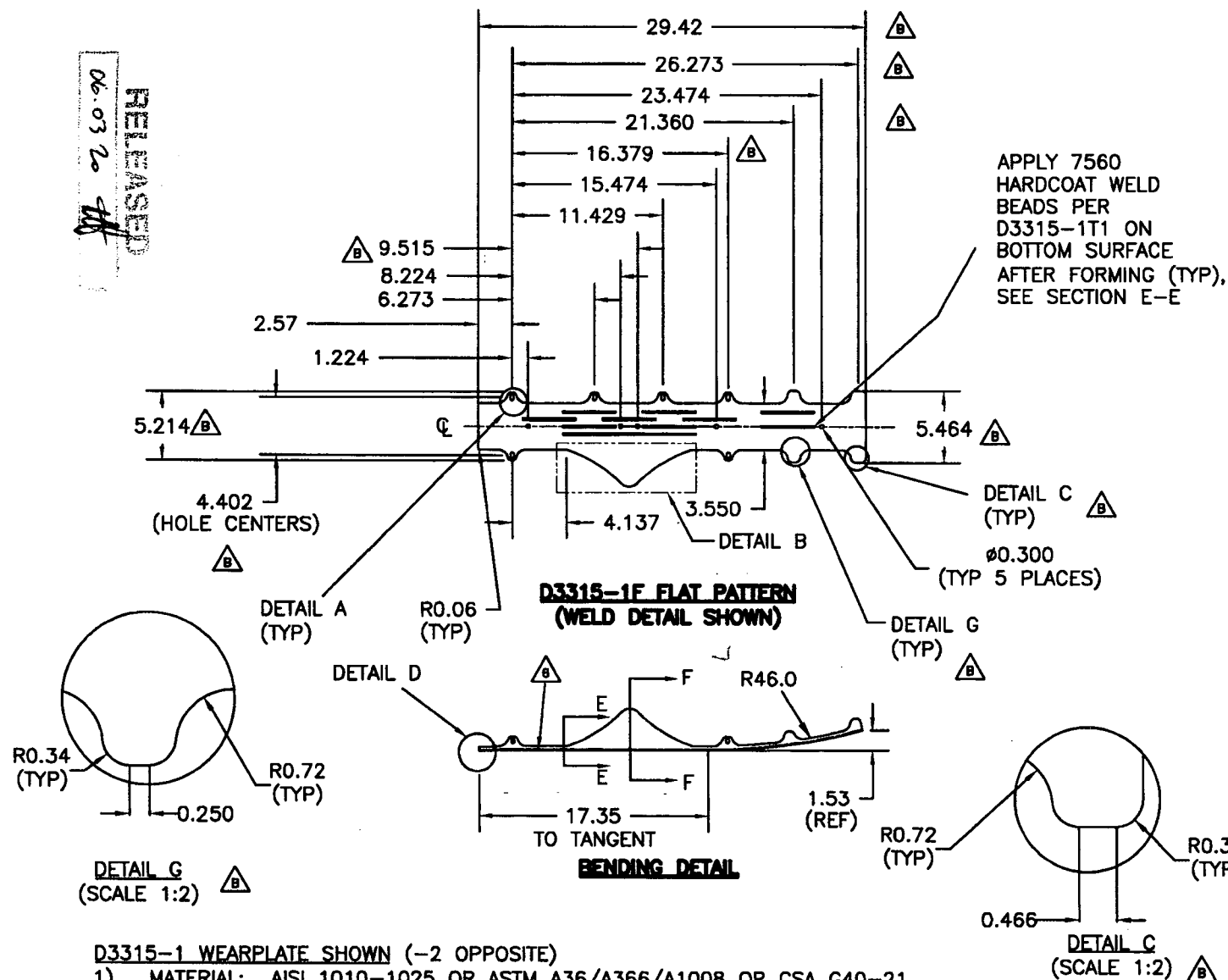
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
04	04	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3315
DATE	TITLE	SCALE
06.01.31	WEARPLATE	1:12
A	04.09.10	NEW ISSUE
B	06.01.31	UPDATE DIMENSIONS



D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)

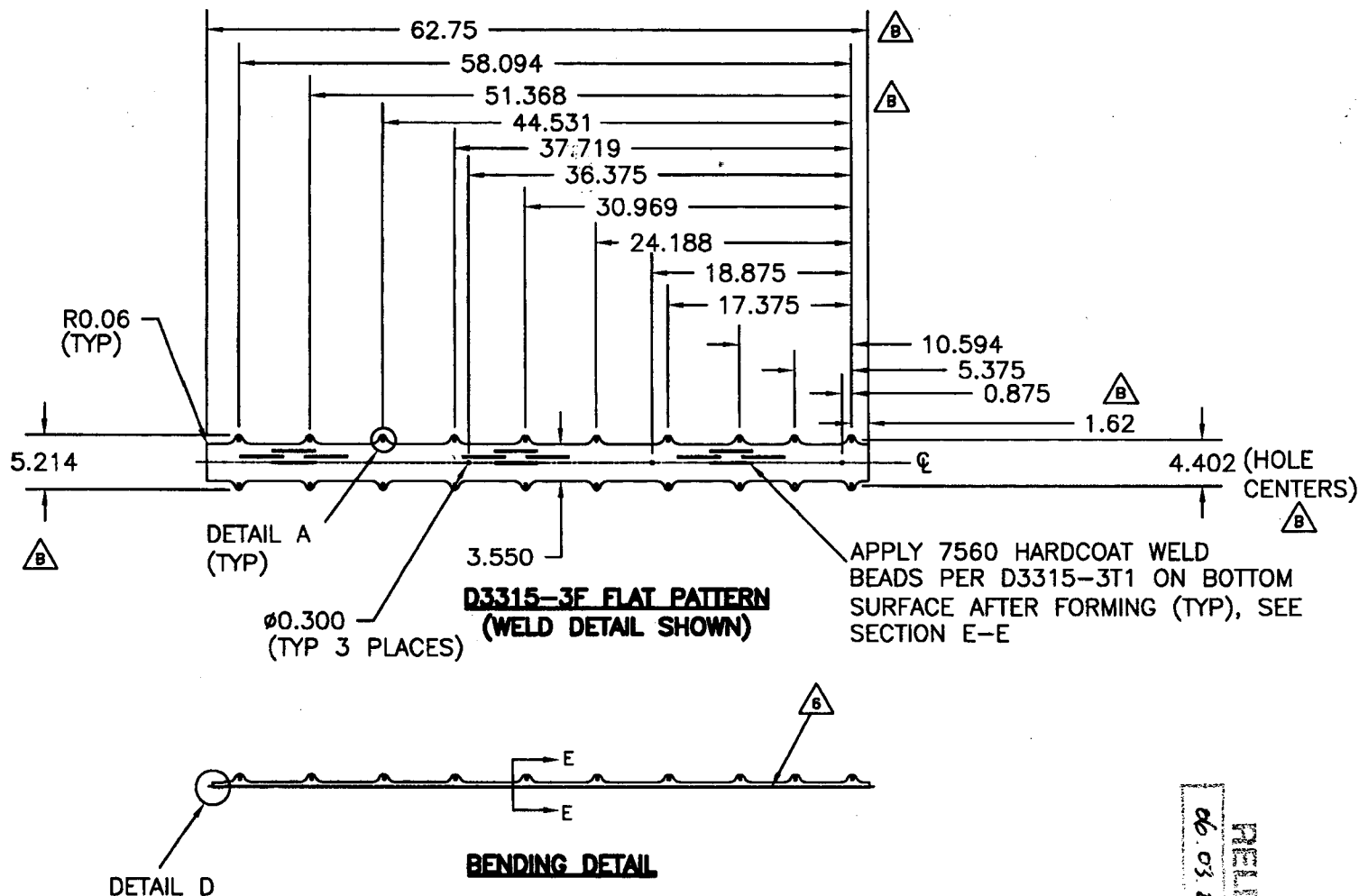
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- *TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X.
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED

06.03.20

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DART

**D3315-3F FLAT PATTERN
(WELD DETAIL SHOWN)**

D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

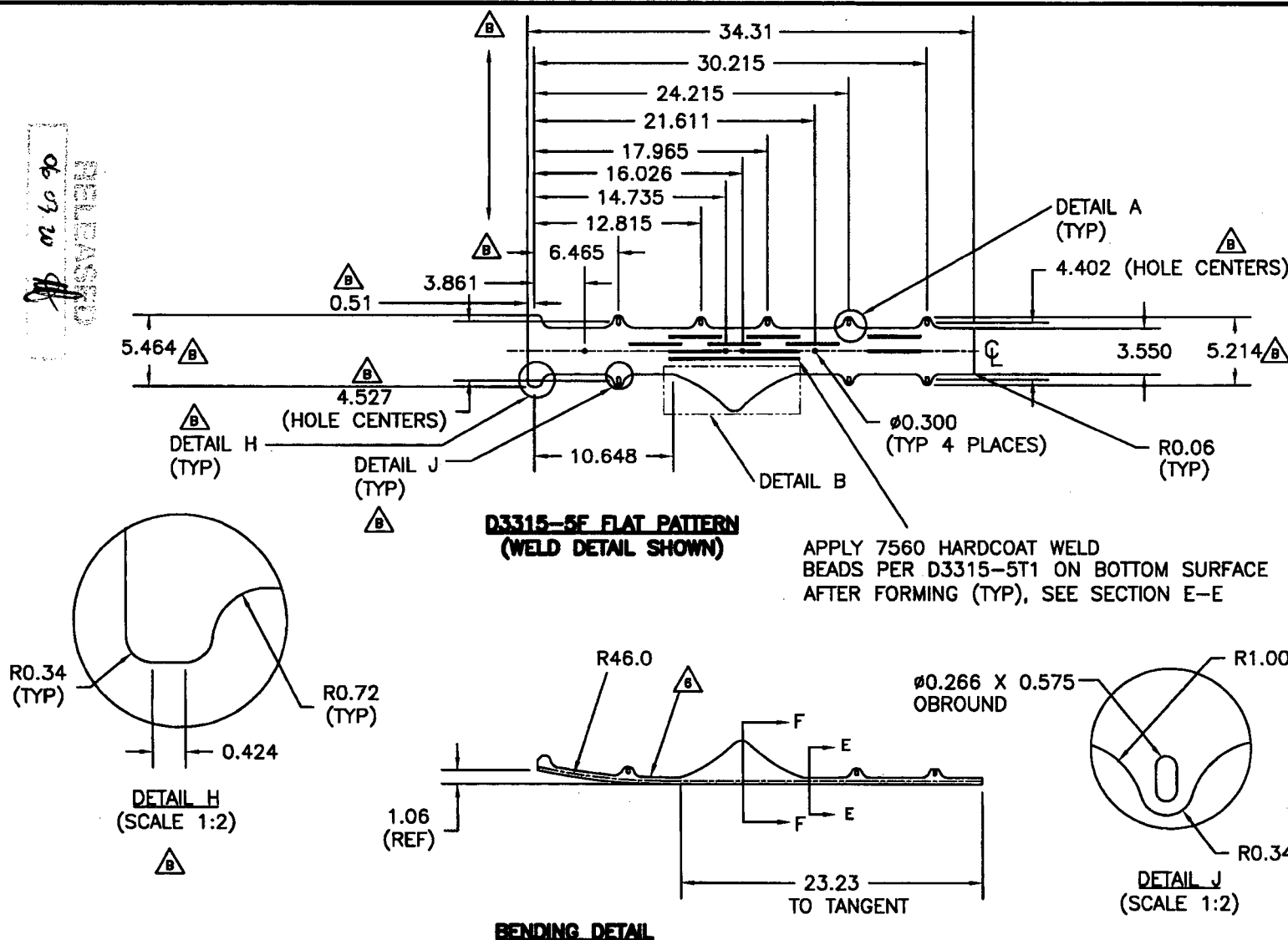
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	REV. B
DATE	06.01.31	DRAWING NO.	D3315	SHEET 2 OF 4
TITLE	WEARPLATE	SCALE	1:16	

RELEASED
26.03.20

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. B
DATE	06.01.31			D3315	SHEET 3 OF 4
				TITLE	SCALE
				WEARPLATE	1:12



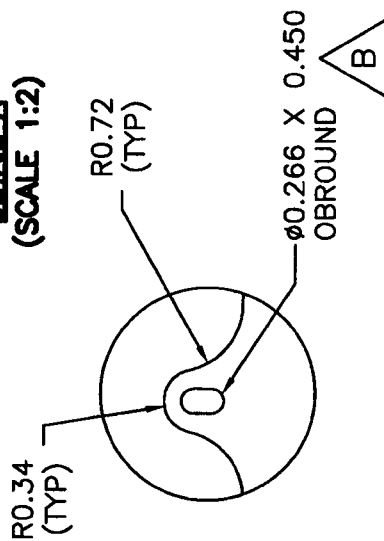
D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DART

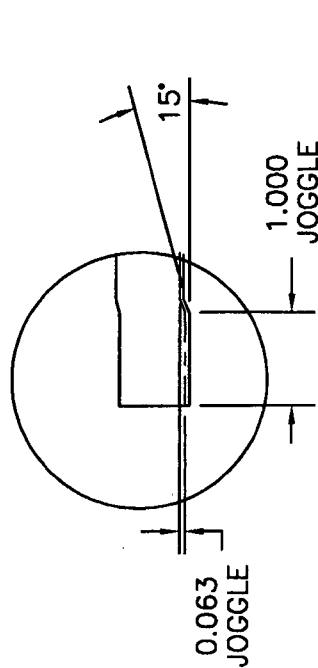
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31		TITLE WEARPLATE	SCALE NTS

DETAIL A
(SCALE 1:2)

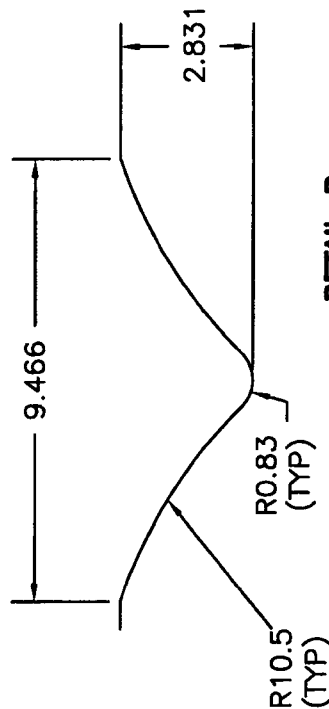


RELEASED

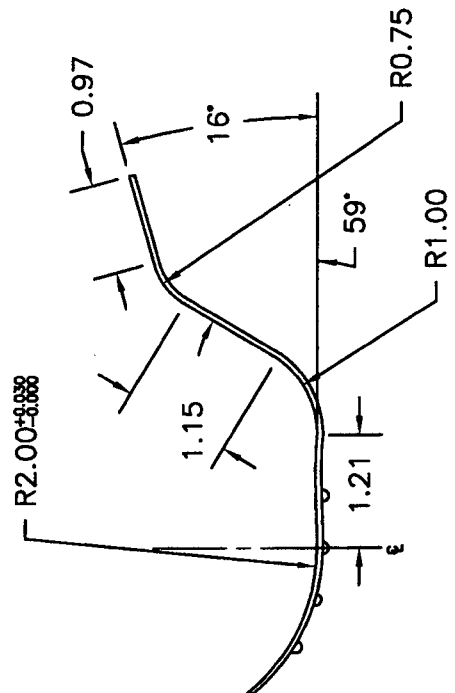
06.03.20



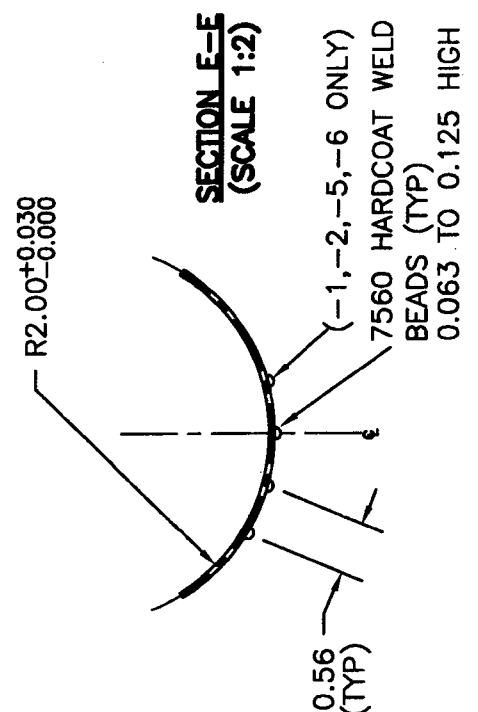
DETAIL D
(SCALE 1:2)



DETAIL B
(SCALE 1:4)



SECTION F-F
(SCALE 1:2)



SECTION E-E
(SCALE 1:2)

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DART AEROSPACE LTD		Work Order: 36171
Description: WEAR SHOE		Part Number: D3315-3
Inspection Dwg: D3315-3 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.266	+/- .010	.267	X			
.450	+/- .010	.453	X			
Ø .300	+ .006 - .001	.301	X			
3.550	+/- .010	3.555	X			
4.402	+/- .010	4.400	X			
5.214	+/- .010	5.212	X			
1.62	+/- .030	1.62	X			
.875	+/- .010	.875	X			
5.375	+/- .010	5.374	X			
10.594	+/- .010	10.594	X			
17.375	+/- .010	17.375	X			
18.875	+/- .010	18.875	X			
24.188	+/- .010	24.188	X			
30.375	+/- .010	30.375	X			
37.719	+/- .010	37.719	X			
44.531	+/- .010	44.531	X			
51.368	+/- .010	51.368	X			
58.094	+/- .010	58.094	X			
62.75	+/- .030	62.75	X			

Measured by: IB	Audited by: J	Prototype Approval: 1/17
Date: 07-12-10	Date: 2/12/10	Date: 1/17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	